

Date: Thursday, 2/23/2006 10:24:08 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG BRACKET
 Job Number : 25924
 Estimate Number : 10364
 P.O. Number : N/A Part Number : D3046041
 This Issue : 2/23/2006 S.O. No. : N/A Drawing Number : D3046 REV. A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A
 Previous Run : 25383 Material : N/A
 Written By : SEE COMMENT BELOW Due Date : 3/2/2006 Qty: 3 Um: Each
 Checked & Approved By : 06.02.23
 Comment : Est: A 01.08.27 New issue SM/EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D30461 Lug Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

LUG BRACKET

Qty	Part Number	Description	Batch
1	D3046-1	Lug Bracket	B24715

SB 06/03/05

2.0 D30463 Lug Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

LUG BRACKET

Pick:

Qty	Part Number	Description	Batch
1	D3046-3 (Bell P/N: 206-052-106-1)	Lug Bracket	N/A

Return Authorization # 2426/R455(x1)

Bell original batch# ③ B4071 ① B26224

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Transfer drill holes from D3046-3 into D3046-1 as per Dwg D3046

2- Counter sink inside holes of D3046-1 as per Dwg D3046

3- Deburr

SB 06/03/15 ④

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/23/2006 10:24:08 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 25924

Part Number: D3046041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

DC 06/03/17

(4)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

mm 06 03 17

(4)

7.0

MS20426AD57

Rivet



Comment: Qty.: 10.0000 Each(s)/Unit Total: 30.0000 Each(s)

Rivet

Qty Part Number

Description

Batch

10 MS20426AD5-7

Rivet

113876

W 06-03-14

SB 06/03/17 (4)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3046

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DA 06/03/17

(4)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

DC 06/03/17

(4)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

mm 06 03 17

(4)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: /

C2 06/03/17 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/23/2006 10:24:08 AM
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Drawing Name: LUG BRACKET

Job Number: 25924

Part Number: D3046041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

19 06/03/17

Job Completion



u 06/03/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

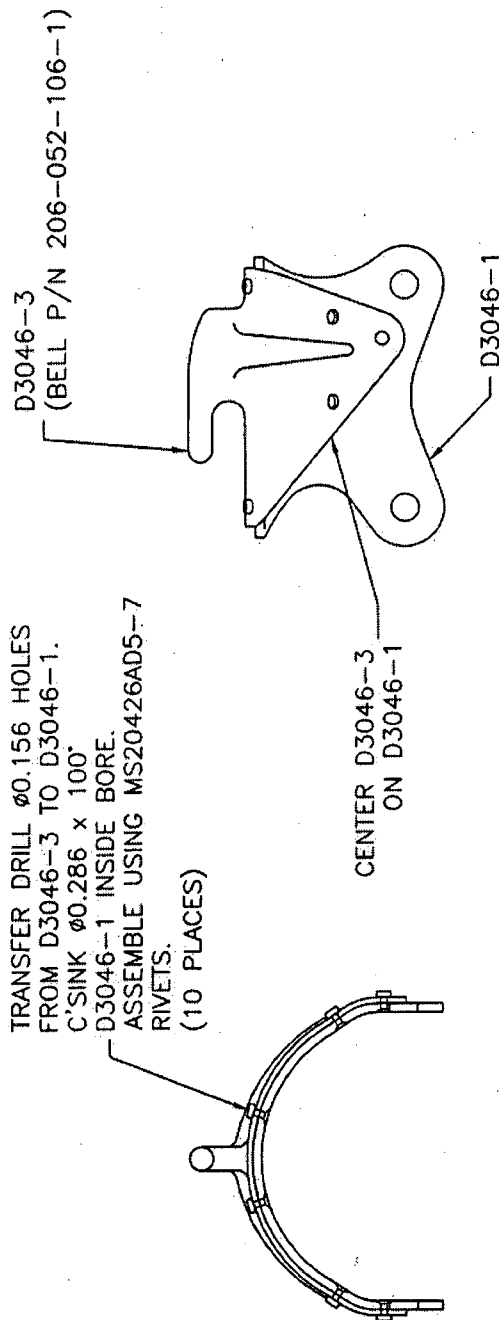
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3046	REV. A SHEET 1 OF 2
DATE 01.08.23		TITLE LUG BRACKET	SCALE 1:2
A	01.08.23	NEW ISSUE	



D3046-041 LUG BRACKET ASSEMBLY

NOTES:
1) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
2) POWDER COAT BOTH PARTS SEPARATELY BEFORE ASSEMBLY.
3) RE-POWDER AFTER ASSEMBLY.
4) REMOVE ALL PAINT/SEALANT FROM D3046-3 BEFORE POWDER COATING.

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WITHOUT NOTICE
WORK ORDER
NO. 25924

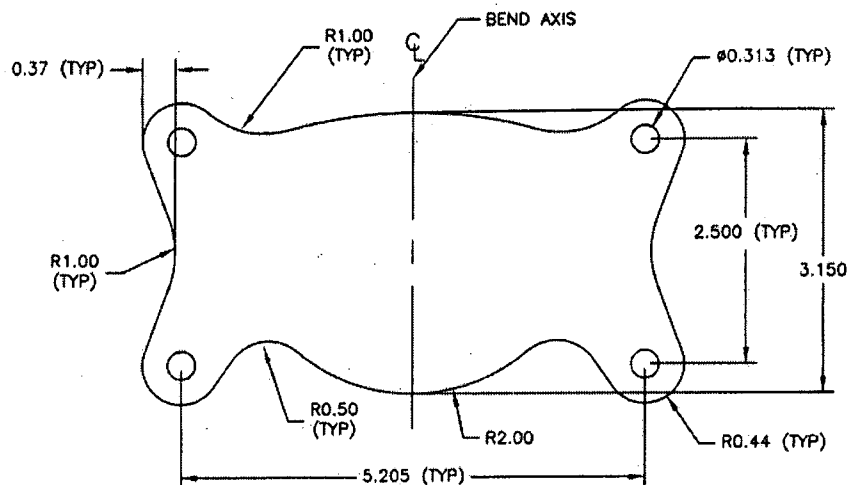
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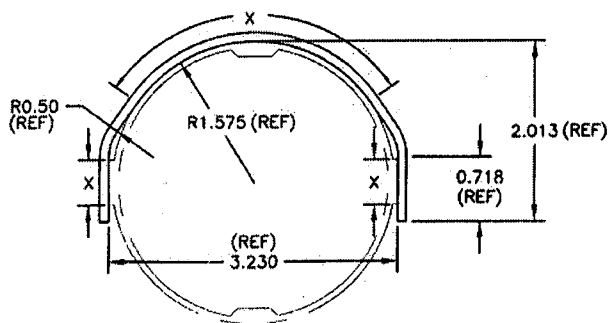
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DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3046	REV. A SHEET 2 OF 2
DATE 01.08.23		TITLE LUG BRACKET	SCALE 1:2



D3046-11 FLAT PATTERN
SYMMETRICAL ABOUT CENTRE-LINES (C)



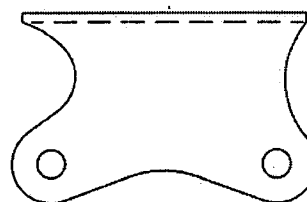
D3046-1
(MAKE FROM D3046-11)

D3046-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



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